

4/03

DART AEROSPACE LTD		Work Order:	20075
Description: Spacer Block Kit		Part Number:	D206-667-011
Dwg: D3193 Rev. B; DSI 9263 Rev. A		Qty:	5 Kit(s)
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: D206-667-011 Kit consists of (2) D3193-041	[Signature]	04.01.12	5
2	DC	Photocopy bluefile and create labels per PPP D206-667-011 CHG001	[Signature]	04.01.12	5
3	MV	Cut (2) blanks per (1) D206-667-011 Kit Cut blanks: 3.500" x 2.500" x 5.000" long Bar Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x03.500) Identify for D3193-1 Batch: M9657 M11226	[Signature]	04/01/24	5
4	MV	Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1	[Signature]	04/01/25	5
5	QC2	Inspect parts as they come off the CNC machine	[Signature]	04/01/25	5
6	MV	Deburr and Tumble	[Signature]	04/01/26	5
7	QC8	Second check	[Signature]	04/01/26	5
8	FP	Chemical Conversion Coat as per QSI 005 4.1	[Signature]	04.01.26	5
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	[Signature]	04.01.27	5
10	QC3	Inspect Powder Coat	[Signature]	04/01/27	5
11	GA	Assemble (2) D3193-041 as per Dwg D3193. (Note: D3193-1 is on BOM as material from Step 3). Pick: Qty Part Number Description Batch 2 D3193-1 Support Bracket B20075 16 MS20426AD3-8 Rivet M14637 M14174 8 MS21073L4 Nut Plate M14397 Identify as D3193-041	[Signature]	04/03/16	5
12	QC5	Inspect work to Step 11	[Signature]	04/03/16	5
13	PK	Pick: Packing Kit Qty Part Number Description Batch 2 D3193-041 Spacer Block B20075 8 AN4-6A Bolt M10768 M13943 8 AN4-7A Bolt M13884 16 AN960JD416 Washer M14312	[Signature]	04/03/16	5
14	QC4	Inspect Kit 100% for completeness on the W/O	[Signature]	04.03.16	5
15	PK	Identify and pack for shipping as per PPP D206-667-011 REV. A	[Signature]	04/03/16	5
16	AC	Cost / part 164.38	[Signature]	04/03/18	5
17	DC	Close W/O 119.53 Inspect Level 21	[Signature]	04.03.26	5

Rev	Date	Change	Revised By	Approved
A	04.01.06	New issue	KJ/JLM	[Signature]

RELEASED
04.01.09